

Work Order ID 110978

January-08-14 12:44:42 PM

1410
110978

Page 1

Item ID: D412-760-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 1/08/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-01-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D412-760	G

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-760-015 CHG002								

DAS 6 9-89
14-2-5
1X
MLJ

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS 32 9-89
14-2-3
(1)

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 6 9-89
14-2-5
1X

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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110978

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 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 1/08/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								DAS
Packaging	Memo	0.00							6
Packaging	Identify and pack for shipping as per PPP D412-760-015								9-89
	Location: <u>062</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-02-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Design									
Doc/Data									
Equip/Tooling									
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Offset/Setup									
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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Required Date: 1/08/14

Required Qty: 1.00

[illegible]

Part Number	Description	Quantity	Unit Price	Total Price	Material	Finish	Notes
D3574-5	Cabin Floor Protector	6	0.0000	110.53	Manufactured	No	110.53
D3574-6	Cabin Floor Protector	6	0.0000	110.53	Manufactured	No	110.53
D3575-5	Cargo Floor Protector	6	0.0000	110.53	Manufactured	No	110.53
D3575-6	Cargo Floor Protector	6	0.0000	110.53	Manufactured	No	110.53
D3580-1	Joggle Bracket	6	59.0000	354.00	Manufactured	No	354.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST055	59	
104313	35	
108217	24	

D3628-1	Manufactured	No	110	110	Each	346.0000
Cupped Washer						

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
83587	10	
ST057	336	
96822	336	

D3628-3	Manufactured	No	110	Each	453.0000
Cupped Washer					

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST057	453	
96308	453	

DAS
6
9-89

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

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Page 2

Work Order ID: 110978
 Parent Item: D412-760-015
 Parent Item Name: Cabin Floor Protector

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

MS24694-S100

Purchased No

110 Each 157.0000

Flat Head Screw

DAS
6
9-89

Location

Loc Qty

Loc Code

ST304

157

125535

157

MS24694-S54

Purchased No

110 Each 338.0000

SCREW

DAS
6
9-89

Location

Loc Qty

Loc Code

ST303

338

125535

338

NASH149D0363J

Purchased No

110 Each 3,714.0000

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

154

124392

154

ST510a

3560

m126319

2360

m127813

1200

NASH149D0463J

Purchased No

110 Each 1,400.0000

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

ST510a

1400

M127813

1400

m125535

m125535

m126319

m127693

14/2/4

DAS
31
9-89

DAS
31
9-89

DAS
31
9-89

DAS
31
9-89

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